

Work Order ID 78979

Tuesday, January 17, 2012 2:59:46 PM

78979

Ship Jan 27th
Page 1

Item ID: D212-725-1-247

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Cam

Stop ***NS2***

Start Date: 1/17/2012 Start Qty: 3.00

3

Cust Item ID:

Required Date: 1/27/2012 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: mf

Date: 12-01-17

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D212-725-1-D4163	Rev. A

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 3.250" long

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio FA843 and DWG

Folio rev: AA

Dwg Rev: A

Deburr as per Dwg

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78979

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Date: _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Tool ID	Tool #	Plan Code
---------	--------	-----------

0.00

120

Memo

Quality Control

0.00

150

QC

Quality Control

0.00

160

HandFinish

Hand Finishing

W/O:		WORK ORDER CHANGES					
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3118 27 Jan

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Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cam

Stop

NS2

Start Date: 1/17/2012 Start Qty: 3.00

3

Cust Item ID:

Required Date: 1/27/2012 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

3X PM 12/01/24

200

Identify as per dwg & Stock Location:

0.00

200

Packaging

Memo

0.00

Packaging

*Repack 1
2 ST 382*

Repack 12/24 (3)

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/1/25

*MF
12-01-24*

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, January 17, 2012 2:59:46 PM

Page 1

Work Order ID: 78979

Parent Item: D212-725-1-247

Parent Item Name: Cam

Start Date: 1/17/2012

Required Date: 1/27/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.625X02.500 6061-T6 Bar .625 x 2.50		Purchased	No			100	f	0.5000	0.3	0.9473684			

12-01-23

Location

Loc Qty

Loc Code

MAT002

0.5

114351

0.5

6061-T6 B.750 2500.

Two Batch only.

Jan/12.01.21.

M17037

m

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

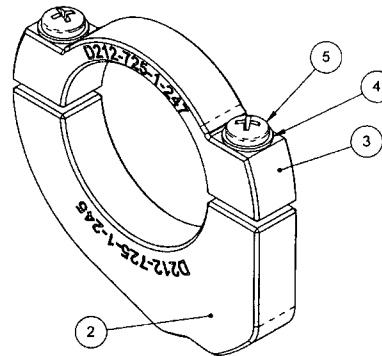
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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ITEM	QTY -947	PART NUMBER	DESCRIPTION
1	X	D212-725-1-947	CAM ASSEMBLY
2	1	D212-725-1-245	CAM BASE ASSEMBLY
3	1	D212-725-1-247	RETAINER
4	2	NAS1149D0332J	WASHER
5	2	MS27039-1-15	SCREW



D212-725-1-947 CAM ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.21 lbs

A	NEW ISSUE	RF	11.02.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4163	SHEET 1 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CAM ASSEMBLY	NTS
DATE	11.02.24	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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RELEASED
2011-08-23
WJD

78979

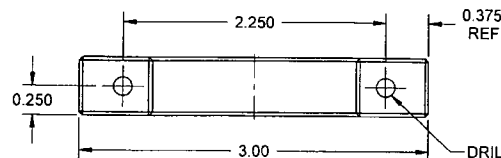
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

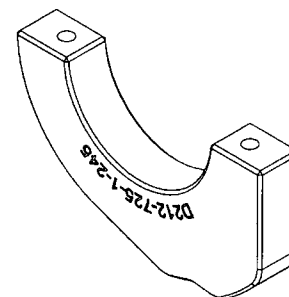
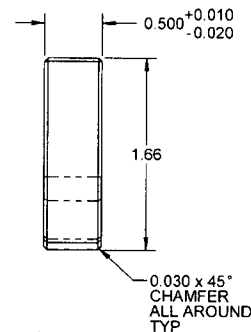
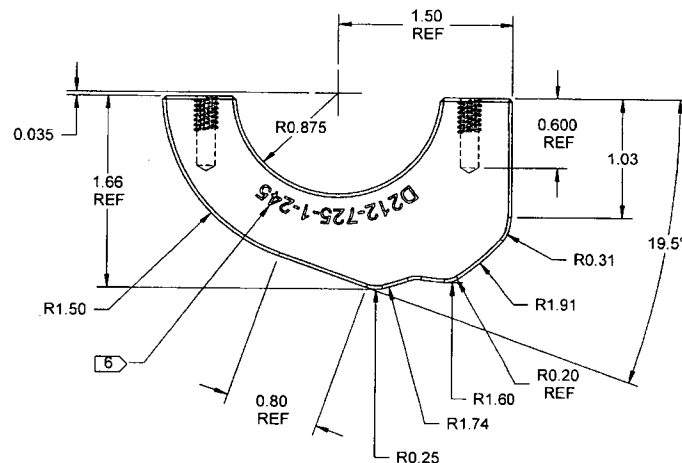
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DRILL AND TAP FOR #10-32 HELICOIL INSERT
 $\varnothing 0.203 \times 0.600$ DP
 2 PL
 INSTALL HELICOIL MS21209-F1-15 OR EQUIVALENT
 FLUSH WITH SURFACE



1697A

RELEASED
 2011-08-23

D212-725-1-245 CAM BASE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO ASSEMBLY
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 AS SHOWN
- 7) WEIGHT: 0.14 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	RF	D4163	SHEET 2 OF 3
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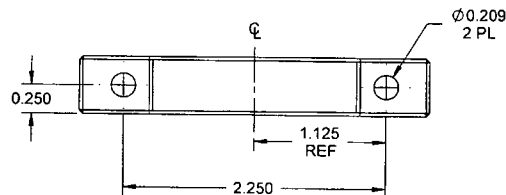
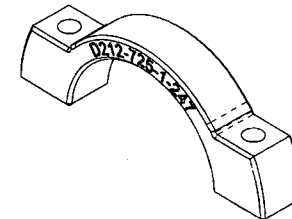
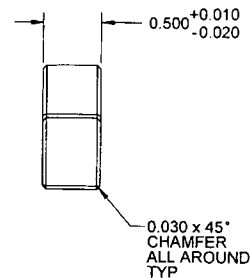
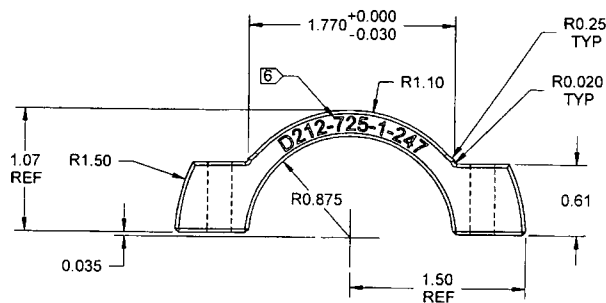
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D212-725-1-247 RETAINER

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 AS SHOWN
- 7) WEIGHT: 0.05 lbs


RELEASED
2011-08-25

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4163	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 3	
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